

Date: Tuesday, 10/23/2007 3:11:37 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: OUTLET WELDMENT (206)
Job Number	: 35336		
Estimate Number	: 10473		
P.O. Number	: <i>N/A</i>	Part Number	: D2414
This Issue	: 10/23/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2414 REV. A
Prsht Rev.	: NC	Project Number	: <i>N/A</i>
First Issue	: <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision	: <i>N/A</i>
Previous Run	: 26906	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 11/6/2007
Checked & Approved By	: <i>[Signature]</i>	Qty:	3 Um: Each
Comment	: Est: 03.04.14 Reformat; Incorporated D2292; D2375-3-08-106; D2403 - D2417 KJ/RF		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2292	Heater Tube 4"
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Heater Tube 4"

Qty	Part Number	Description
1	D2292	4" Ring

Batch

B35339 -> 1
B30600 -> 2

PD 07-10-25

2.0	D2406	3" Heater Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

3" Heater Tube

Qty	Part Number	Description
1	D2406	3" Tubing

Batch

B27124

PD 07-10-25

3.0	D2415	End Plate
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

End Plate

Qty	Part Number	Description
1	D2415	End Plate

Batch

B26913

PD 07-10-25

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Weld D2414 Outlet Assembly as per Dwg D2414 and QSI 004.

PD 07-10-25(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 07/12/16
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/23/2007 3:11:37 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: OUTLET WELDMENT (206)

Job Number: 35336

Part Number: D2414

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10/10/29 (3)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FD 01/10/29 (3)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT ALODINE

counter
11/10/29 (x3)

8.0

OUTSIDE SERV.15

OUTSIDE SERVICES - LF



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 4957

Red Anodize D2414 as per Dwg D2414

Possible Supplier: Anodizing TNM Paint

Ensure Certificate of Conformity is attached

CL0711101 (3)

7/11/29 (3X) SP

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

7-11-02 SD (3X)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7-11-13 (3)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 169

7-11-15 SD 3X

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/11/16 (3)

Job Completion



W 07/11/16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	D2414	REV. A SHEET 1 OF 2
DATE Apr. 6, 1995		TITLE 206 OUTLET WELDMENT SCALE	

RELEASED
96/09/10 BW

QTY	Part No.	Description
X	D2414	OUTLET WELDMENT ASSEMBLY
1	D2292	4" TUBING
1	D2406	3" TUBING
1	D2415	END PLATE

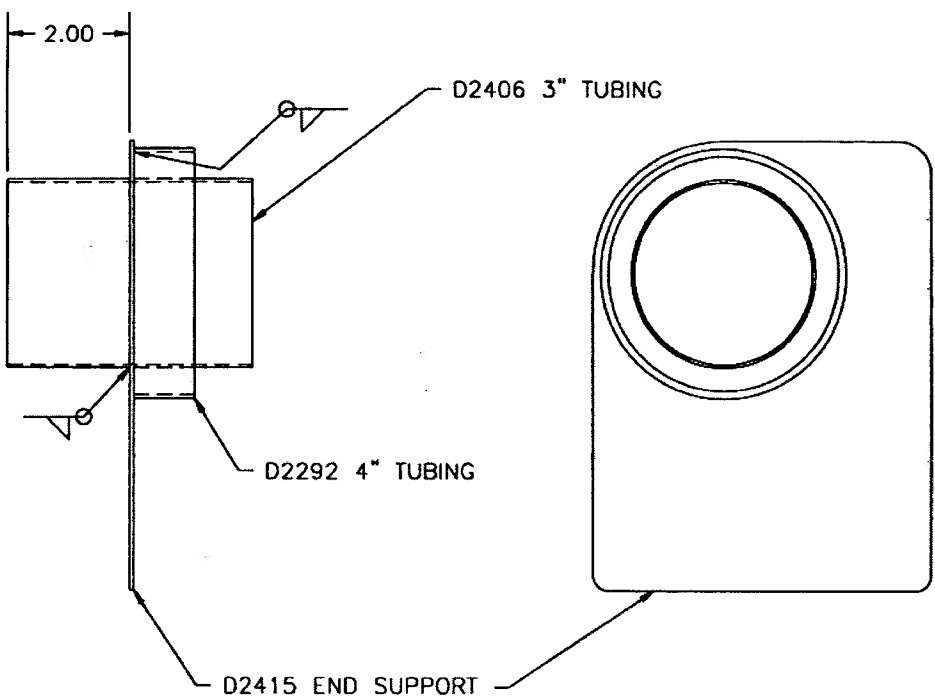
SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35336

DART



PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED Bus	APPROVED Bus	D2414	REV. A
DATE Apr. 6, 1995		TITLE 206 OUTLET WELDMENT	SHEET 2 OF 2
			SCALE

RELEASED
9609/10 Bus



FINISH: ANODIZE

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35336

TNM.

ANODISATION et PEINTURE TNM INC.

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2
Telephone: (514) 429-7777 Fax: (514) 429-5108
Certifié ISO 9001-2000 / AS9100 certified
approuvé NADCAP approved

59970

09-Nov-2007

CLIENT / CUSTOMER:

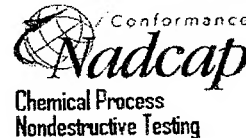
DART AEROSPACE LTD.

1270 ABERDEEN STREET
HAWKESBURY , ONTARIO
K6A 1K7

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITE

PURCHASE ORDER/
NO. DE COMMANDE:

04957



ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PART PROCESS & TREATMENT
1	4	4	D2413B35335	RED ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER
3	3	3	D2414B35336	RED ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER
1	2	2	D2224B34970	RED ANODIZE PER MIL-A-8625F TYPE II CLASS 2 ALL OVER

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.
All parts are processed, tested, and inspected to the requirements of above specifications.
Travel cards have been filled and are available for viewing upon request.
NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures"
NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed:

[Signature] 13

ENT / CUSTOMER:

RT AEROSPACE LTD.

0 ABERDEEN STREET

WILKESBURY, ONTARIO

A 1K7

PURCHASE ORDER/ 04957
NO. DE COMMANDE:

CONDITIONS / TERMS:

NET 30 JOURS / NET 30 DAYS

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION	PRIX UNITAIRE UNIT PRICE	EXTENSION
1	4	4	D2413B35335	\$0.00	\$0.00
3	3	3	D2414B35336	\$0.00	\$0.00
1	2	2	D2224B34970	\$0.00	\$0.00
			MINIMUM CHARGE		\$120.00
				SUB TOTAL:	\$120.00
				TPS/GST:	\$7.20
				TVQ/PST:	\$0.00
				TOTAL AMOUNT DUE:	\$127.20

No de TPS / GST #: 891559734 RT

No de TVQ / QST #: 1019307154 TQ000

CERTIFICAT DE CONFIRMITE EMIS POUR CHAQUE PROCEDURE
CERTIFICATE OF COMPLIANCE ISSUED FOR EACH PROCESS

En cas de perte ou de dommages dû a la la valeur intrinsèque de certaines responsabilit  se limitera   deux fois la valeur du
traitement des pi ces perdues ou endommag es.
Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.

STRUCTURE INM INC.

21 chemin de l'Aviation, Pointe-Claire, QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / ISO 9001-2000 certified

Certifié NADCAP / NADCAP certified

**PACKING
SLIP**

59970

09-Nov-2007

CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**PURCHASE ORDER/
NO. DE COMMANDE:**

04957

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION
1	2	2	D2224B34970
1	4	4	D2413B35335
3	3	3	D2414B35336

PICKED UP BY / RECU: _____

En cas de perte ou de dommages dû à la la valeur intrinsèque de certaines responsabilité se limitera à deux fois la
valeur du traitement des pieces perdues ou endommagées.
Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.